

Page 1

April-02-15 10:28:43 AM

Reference:

Run	Start	*NR1*
	Stop	*NR2*

Draw Nbr	Revision Nbr
D4017	E
D4020	A

5- Weld D4672-3 blanking plates as per dwg

Quality Control

Memo	0.00
-------------	------

1 MAY 12 2015 DAS 24 9-89

① 15.05.12

Work Order ID 131290

131290

Page 2

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Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Basket Base Assembly (350)
 Start Date: 4/02/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/17/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

1 15-0512 15-5-14 DAS 34 9-89

Work Order ID 131290

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Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Basket Base Assembly (350)
 Start Date: 4/02/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/17/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat M 131545								
	1ST COAT: START TIME: 3:25 OVEN TEMPERATURE: 400° FINISH TIME: 3:55								
	***** 2nd coat if necessary *****								
	M 131545 2ND COAT: START TIME: 8:15 OVEN TEMPERATURE: 400° FINISH TIME: 8:45								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

1 / 15-5-14. DAS 34 9-89

1 / 15-5-15. DAS 34 9-89

1 x d 11 10/05/14 DAS 15 9-89

Work Order ID 131290

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Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Basket Base Assembly (350)
 Start Date: 4/02/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/17/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.00				1	1	11	15/05/15
Hand Finishing									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00				1			DAG 38 9-89 MAY 19 2015
Quality Control									
170	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

B4032-041 13131288

1 1 11 15/05/15

Work Order ID 131290***131290***

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Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Short Basket Base Assembly (350)
Start Date: 4/02/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/17/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

_____ **ML** _____
MAY 20 2015
ME
15-5-19

Picklist Print

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Page 1

Work Order ID: 131290

131290

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC IPP REV:F 12.07.24 AS PER DWG REV.D DD VERF:EC IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4672-3 *D4672-3* Blanking Plate		Manufactured	No			100	Each	18.0000	2	2		DAS 24 9-89	MAY 12 2015
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				18					
					124076			18		2			
M304EX0.75-16F *M304FX0 75-16F* Expanded Metal Flat SS		Purchased	No			100	sf	1,048.861	19.1516	20		DAS 24 9-89	MAY 12 2015
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				480					
					M131848			480		20			
				WA006				568.8612					
					M131107			129.8612					
					M131629			439					
D4017-1 *D4017-1* Rib		Manufactured	No			100	Each	5.0000	1	1		DAS 24 9-89	MAY 12 2015
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				5					
					123931			5		1			

Picklist Print

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Work Order ID: 131290

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

131290

D4017-041

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

D4017-3	Manufactured	No	100	Each	4.0000	1	1		
D4017-3									
Rib									

**

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	4	
129751	4	

D4017-5	Manufactured	No	100	Each	5.0000	1	1		
D4017-5									
Hinge Rib									

**

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	5	
105016	1	
130176	4	

D4017-7	Manufactured	No	100	Each	23.0000	3	3		
D4017-7									
Rib									

**

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	23	
116025	23	

D4017-9	Manufactured	No	100	Each	8.0000	2	2		
D4017-9									
Rib									

**

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	8	
127720	8	

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Page 3

Work Order ID: 131290

131290

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

D3916-041	Manufactured	No	100	Each	8.0000	2	2			
D3916-041										
Rib Assembly										

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004

8

127444

4

129805

4

D3916-5	Manufactured	No	100	Each	16.0000	1	1			
D3916-5										
Light Rib										

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004

16

120391

4

120393

7

121578

5

D4034-041	Manufactured	No	100	Each	3.0000	1	1			
D4034-041										
Aft Upper Rib Assembly										

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004

3

128381

3

D4034-043	Manufactured	No	100	Each	4.0000	1	1			
D4034-043										
Fwd Upper Rib Assembly										

DAS
24
9-89

MAY 12 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004

4

129683

1

130373

3

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Work Order ID: 131290

131290

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

83.0000

2

2

D2581

Mounting Bracket

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

83

102265

38

127716

45

2

D3913-15

Manufactured No

100

Each

7.0000

1

1

D3913-15

Wide Handle Plate

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

7

117028

1

128895

4

129891

2

B 131002 → 1

D4016-1

Manufactured No

100

Each

36.0000

3

3

D4016-1

Hinge Half, Base

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

36

120115

8

121919

7

129669

21

3

D4020-11

Manufactured No

100

Each

4.0000

2

2

D4020-11

End Mesh, Basket

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA006

4

127394

4

2

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Page 5

Work Order ID: 131290

131290

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

D2931	Manufactured	No	150	Each	1,781.000	2	2
-------	--------------	----	-----	------	-----------	---	---

D2931

Bumper

**

Handwritten: 15/05/15

Location

Loc Qty

Loc Code

ST025A

1781

~~86435~~

1781

D4021-1

Manufactured No

100 Each

25.0000

3

3

D4021-1

Handle Plate

**

DAS
24
9-39

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

25

120273

1

129822

24

D4021-5

Manufactured No

150 Each

14.0000

2

2

D4021-5

Blanking Plate

**

Handwritten: B130947 -> 3

Location

Loc Qty

Loc Code

ST081

14

103829

5

117489

2

129590

7

AN3-10A

Purchased No

150 Each

106.0000

6

6

AN3-10A

Bolt

**

Handwritten: 15/06/15

Location

Loc Qty

Loc Code

GA

38

m131320

38

ST338a

68

m130466

68

Handwritten: x to

Picklist Print

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Work Order ID: 131290

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

131290

D4017-041

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

150

Each

2,952.000

2

2

NAS1149DN832.J

Washer

all 13/02/15

Location

Loc Qty

Loc Code

CA

84

M129499

84

MF4

185

M129541

185

ST260a

2500

M131697

2500

ST270

183

124555

15

M131317

168

x2

MS20600-AD4W3

Purchased

No

150

Each

564.0000

2

2

MS20600-AD4W3

Cherry Rivets

all 13/05/15

Location

Loc Qty

Loc Code

GA

480

m129795

480

WA003

84

m130018

84

x2

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Shop Packet Print

Page 6

Picklist Print

April-02-15 10:28:42 AM

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Work Order ID: 131290

131290

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,867.000

6

6

MS21042L3

Nut

lll 15/05/19

Location

Loc Qty

Loc Code

FP001

420

M130922

420

11132123

x6

GA

798

M131317

798

ST305

649

116549

12

126333

49

M128754

2

M131624

586

NAS1149F0332P

Purchased

No

150

Each

3,916.000

12

12

NAS1149F0332P

Washer

lll 15/05/19

Location

Loc Qty

Loc Code

GA

222

122063

222

ST260a

2586

m128401

6

m131026

80

m131697

2500

st268

1108

123900

460

m130325

562

m130388

86

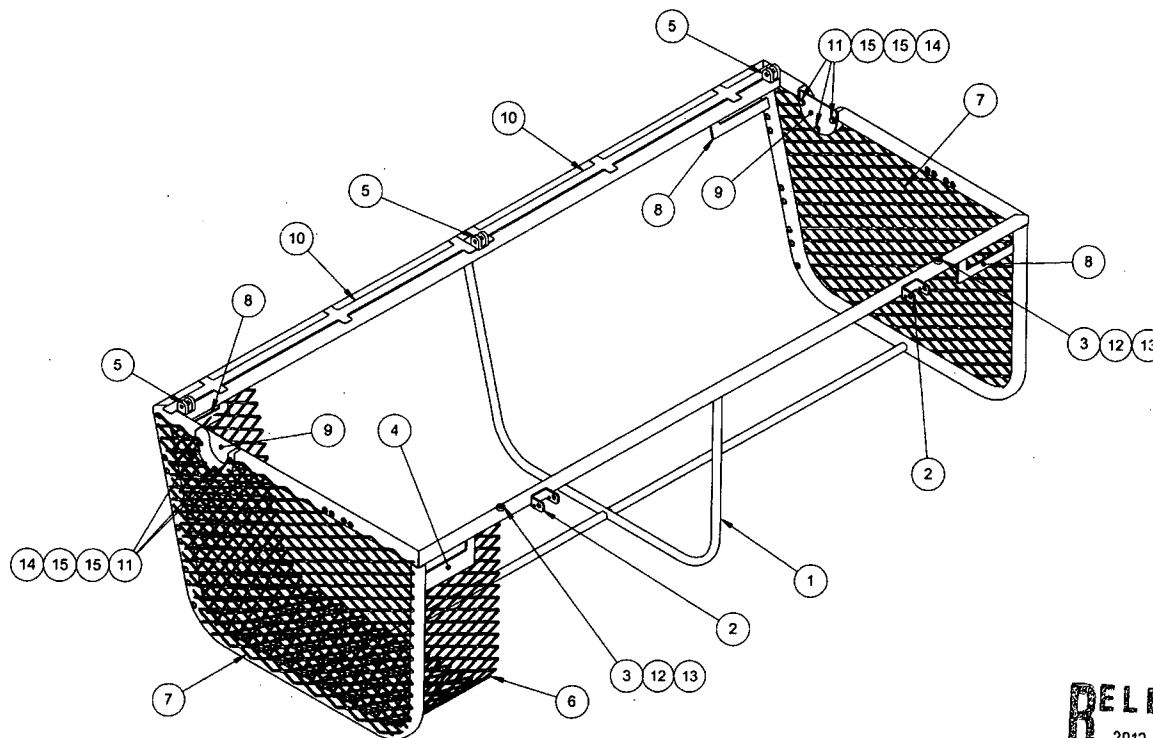
x12

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Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-3	BLANKING PLATE
11	6	AN3-10A	BOLT, MACHINE
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET, BLIND, PAN-HEAD
14	6	MS21042L3	NUT, SELF-LOCKING
15	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

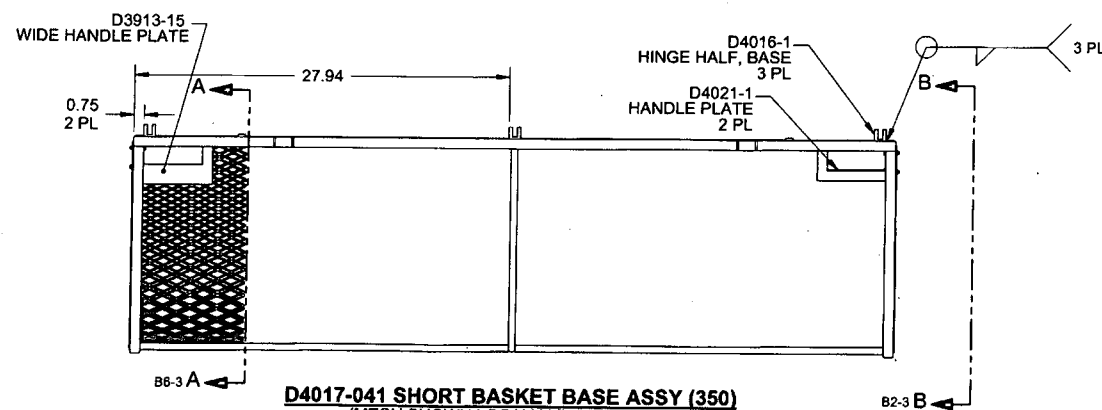
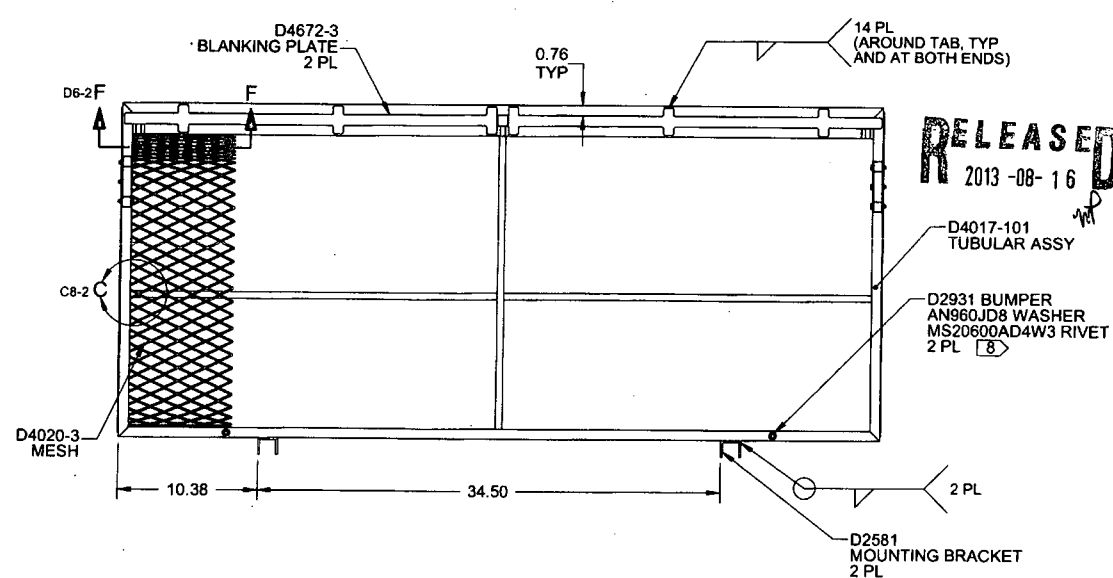
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2013-08-16

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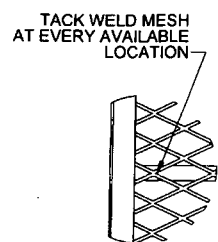
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

E	PICTORIAL UPDATE TO MULTIPLE VIEWS FOR CHANGES TO D4034-043. A4-4 28.13 DIM IS NOW REF.	AJS	13.07.18
D	ADD D4672-3 (ZN C5-1, D4-1, D6-1, D3-2, AND D4-2). REASON: PAR12-197.	MB	12.06.18
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4017 TITLE SHORT BASKET BASE ASSY (350) NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.18	REV. E SHEET 1 OF 5 SCALE NTS	

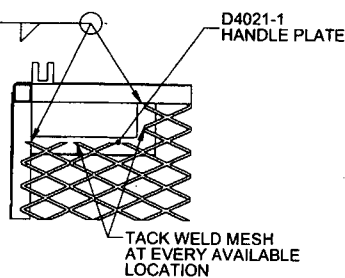
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2013-08-16



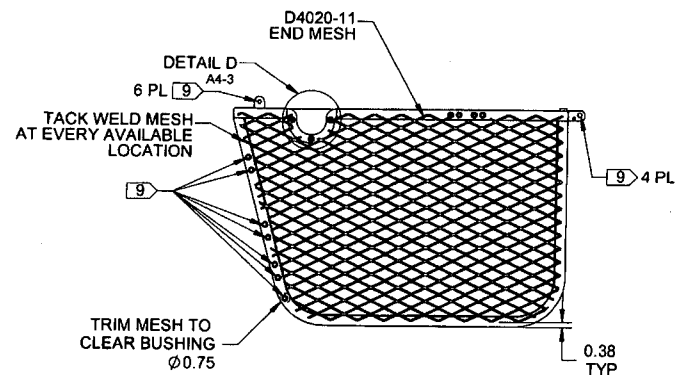
D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



DETAIL C D5-2



SECTION F-F D5-2
TYPICAL FOR ALL
HANDLE PLATES



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D4017	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

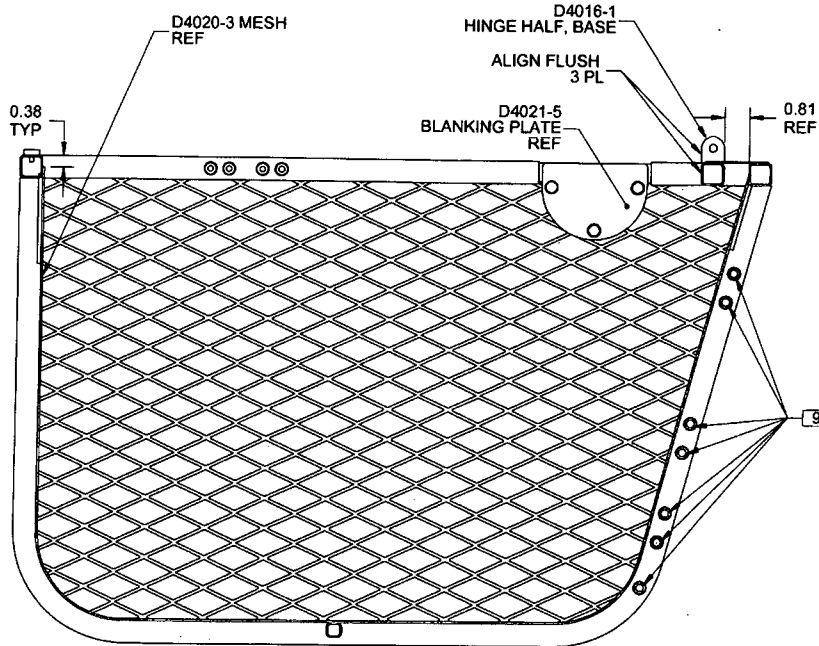
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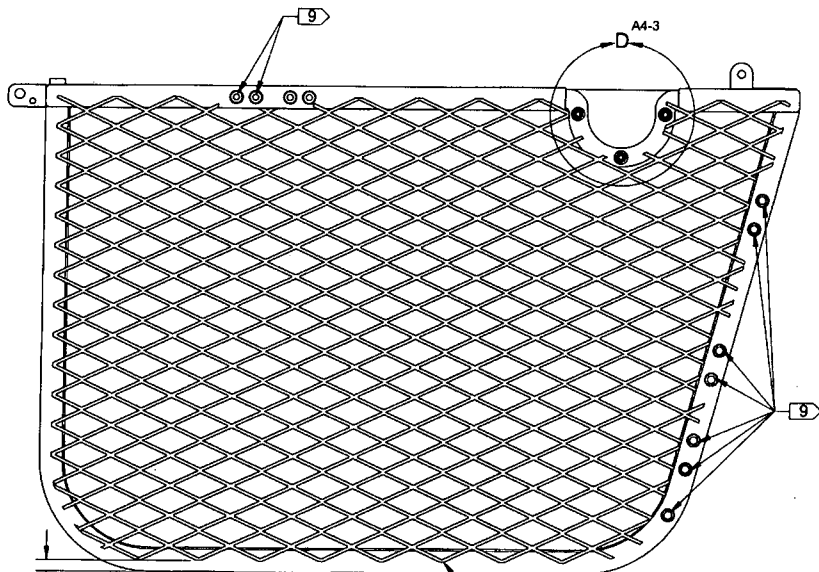
C

B

A



SECTION A-A A5-2



VIEW B-B

A2-2

8
D4021-5
BLANKING PLATE

AN3-10A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
3 PL

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR FASTENERS

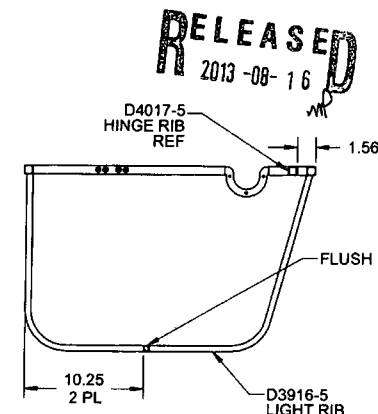
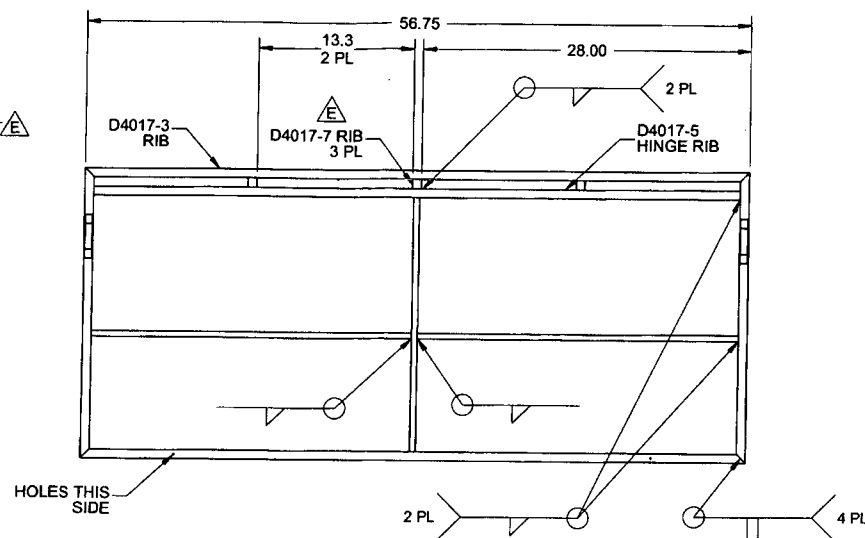
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B7-2

RELEASED
2013-08-16
MP

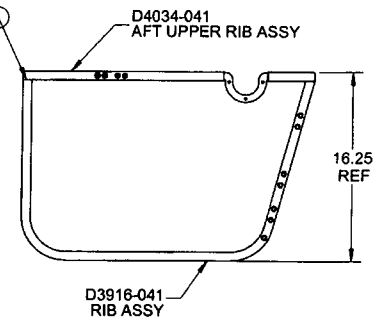
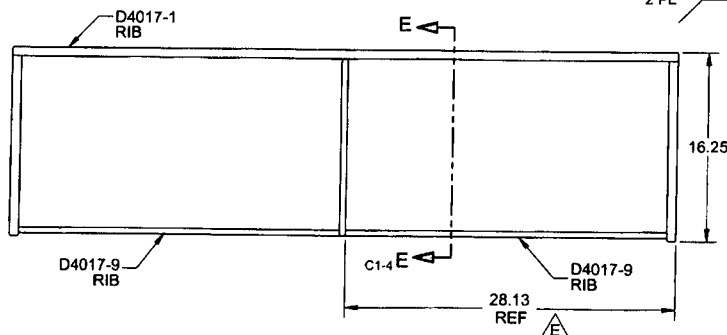
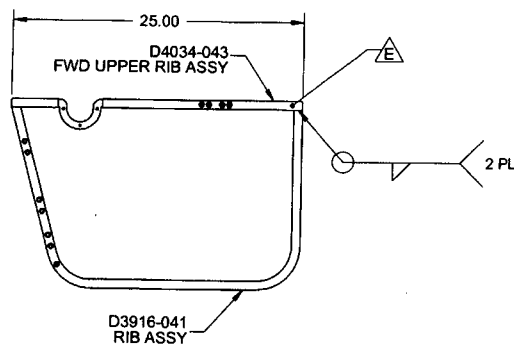
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4017	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	3	D4017-7	RIB
5	2	D4017-9	RIB
6	1	D3916-5	LIGHT RIB
7	2	D3916-041	RIB ASSY
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



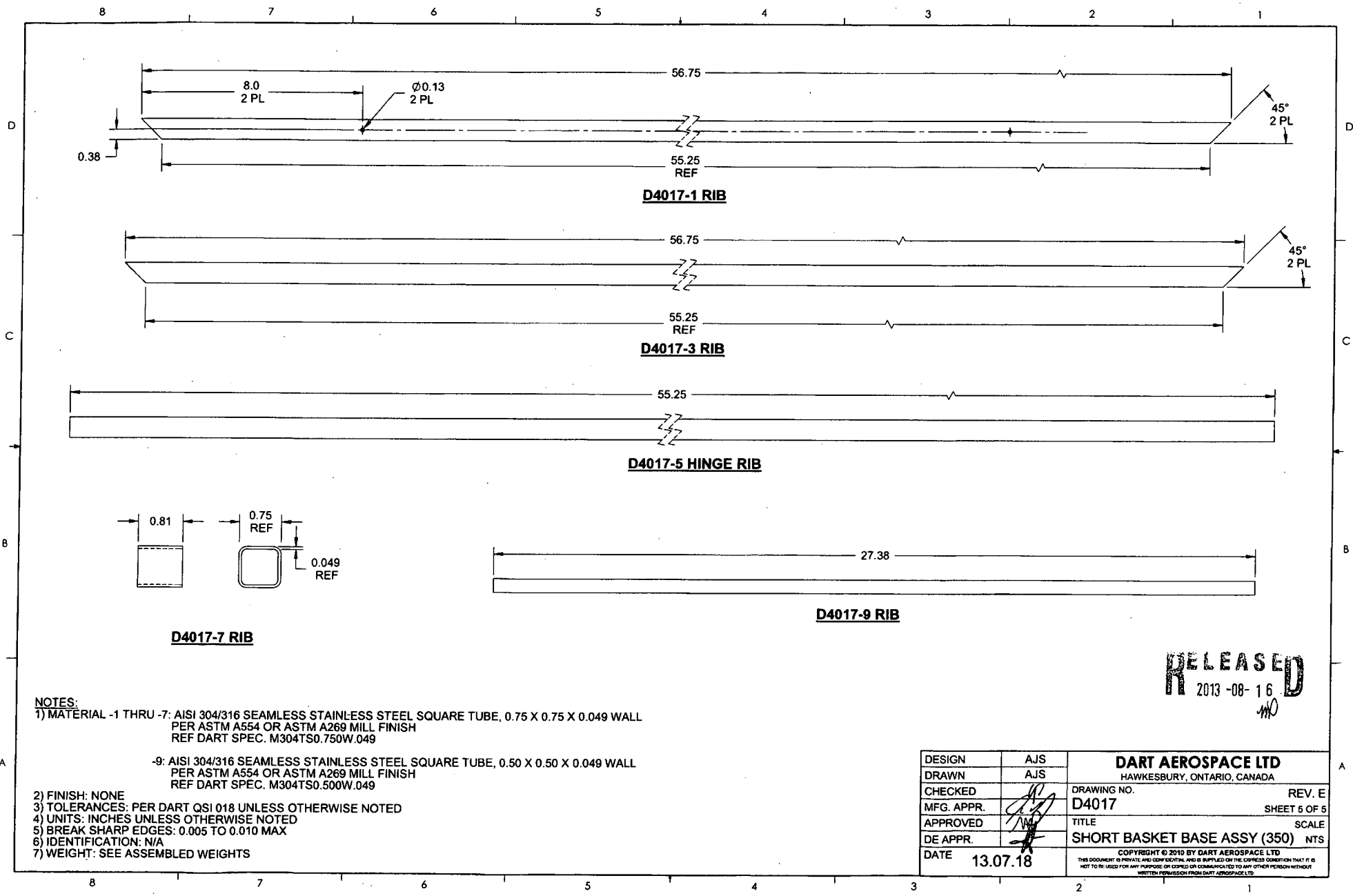
SECTION E-E A4-4



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.38 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. E
MFG. APPR.	21	D4017	SHEET 4 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	14	SHORT BASKET BASE ASSY (350)	NTS
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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4017	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET BASE ASSY (350) NTS	
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